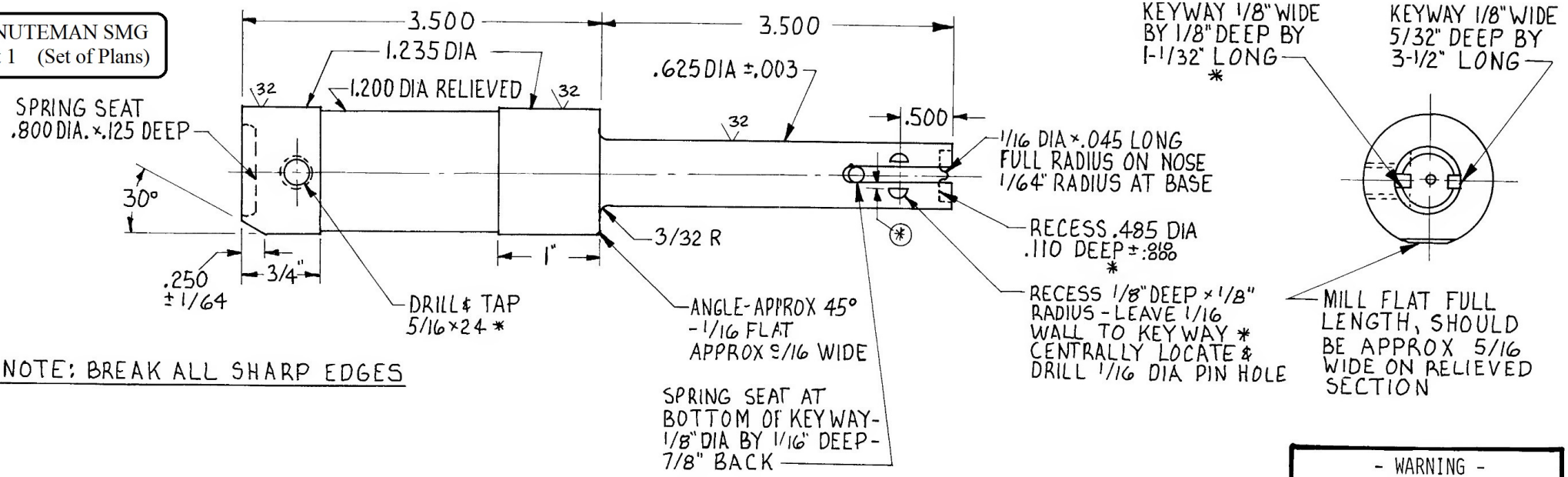
MINUTEMAN SMG
Part 1 (Set of Plans)

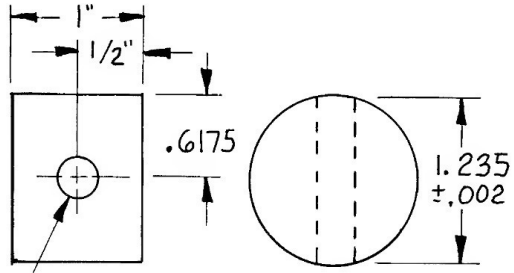


* NOTE: BREAK ALL SHARP EDGES

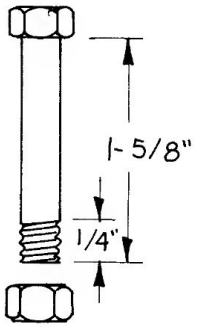
BREECH-BLOCK. INTL-HRS/ C/HARDEN .010-.015 DEPTH

- WARNING -

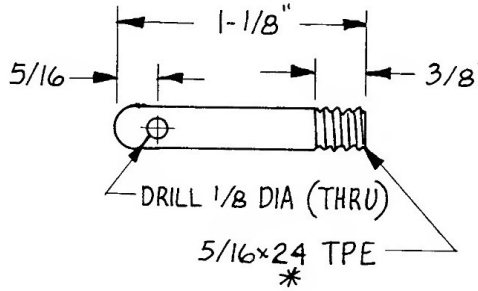
THE ACTUAL CONSTRUCTION OF THIS WEAPON WOULD BE IN VIOLATION OF FEDERAL LAWS.



RETAINING PLUG - MTL 6061-T6 ALUM

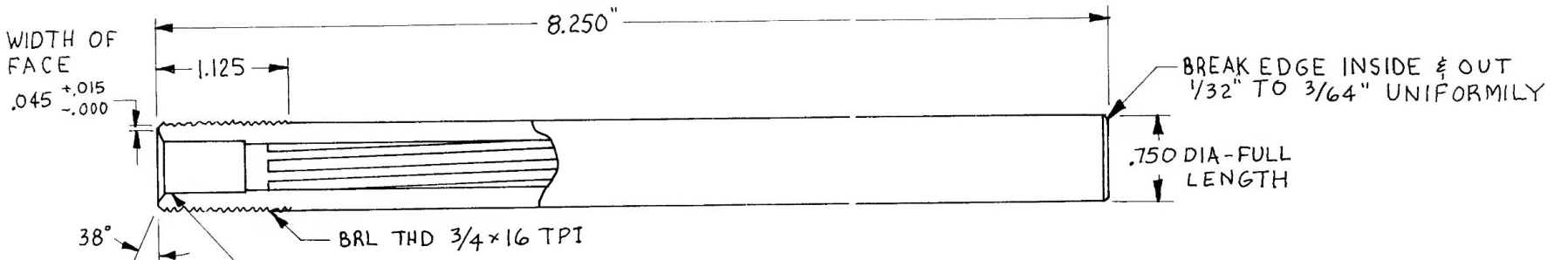


RETAINING PLUG BOLT & NUT
5/16×18 STL PURCHASED
(HEX HEAD) & NUT - SELF LOCKING

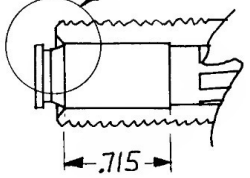


COCKING KNOB - MTL 5/16 BOLT-STL

"MINUTEMAN PART 1". THIS SET OF PLANS IS TO BE READ JOINTLY WITH THE CHANGES MADE BY GUNSMITH GARY HILL AND OTHER INFORMATION INCLUDED IN THE "MINUTEMAN PART 2" DOCUMENT



CHAMBER TO THIS DEPTH .715 FROM 38° LOADING CONE



- WARNING -

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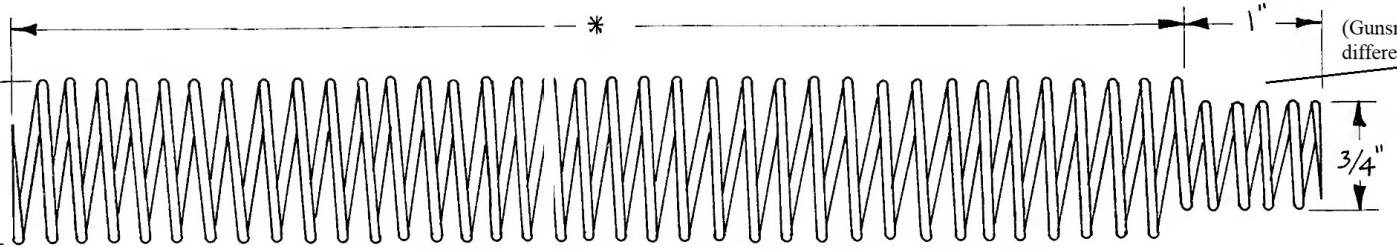
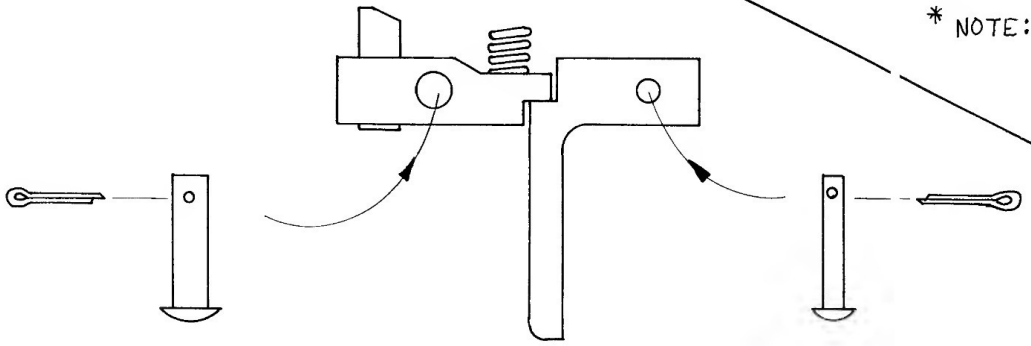


(Gunsmith says making spring of different diameter is unnecessary)

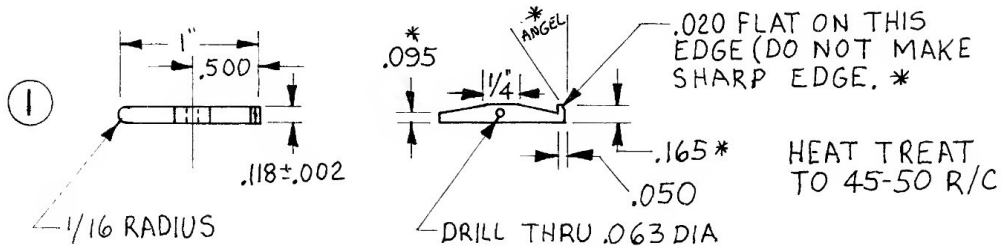
THRUST SPRING-STL-NON-FATIGUING (PURCHASED)

* NOTE: LENGTH OF SPRING & TENSION WILL HAVE TO BE ADJUSTED - DEPENDING ON TYPE SPRING USED SHOULD BE APPROX 9 1/2" LONG



ASSEMBLY OF TRIGGER & SEAR IN PROPER RELATION WITHIN HOUSING

* EXTRACTOR, PIVOT PIN & SPRING (INT'L STEEL)



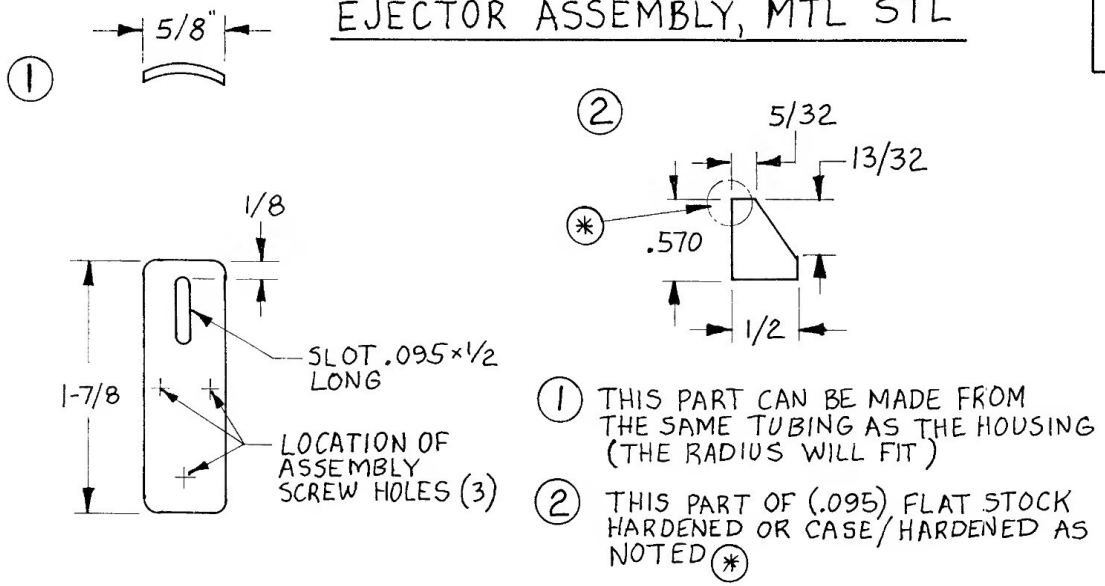
①

NOTE: THIS PART MIGHT REQUIRE SOME HAND FITTING - (1/32"-3/64" LIP TO SNAP INTO EXTRACTOR GROOVE IN CASE)

② * EXTRACTOR PIN .062 DIA. x .275 LONG (STL)

③ * EXTRACTOR SPRING .110-.120 DIA. x 1/8" LONG

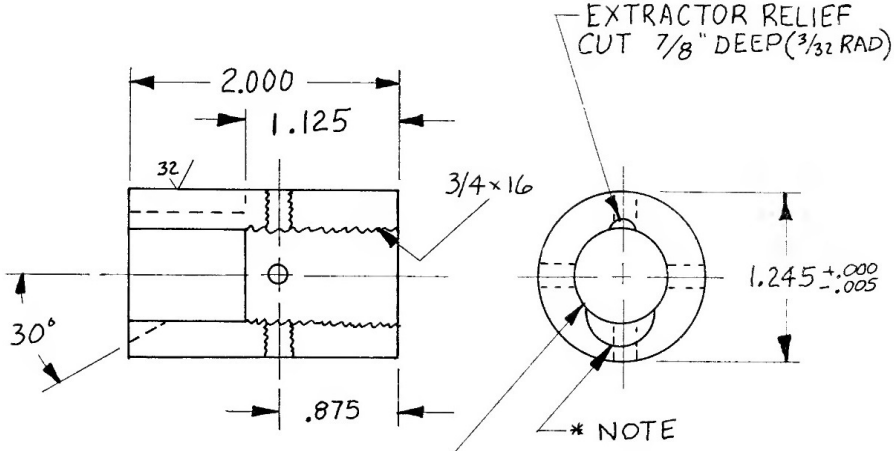
EJECTOR ASSEMBLY, MTL STL



① THIS PART CAN BE MADE FROM THE SAME TUBING AS THE HOUSING (THE RADIUS WILL FIT)

② THIS PART OF (.095) FLAT STOCK HARDENED OR CASE/HARDENED AS NOTED (*)

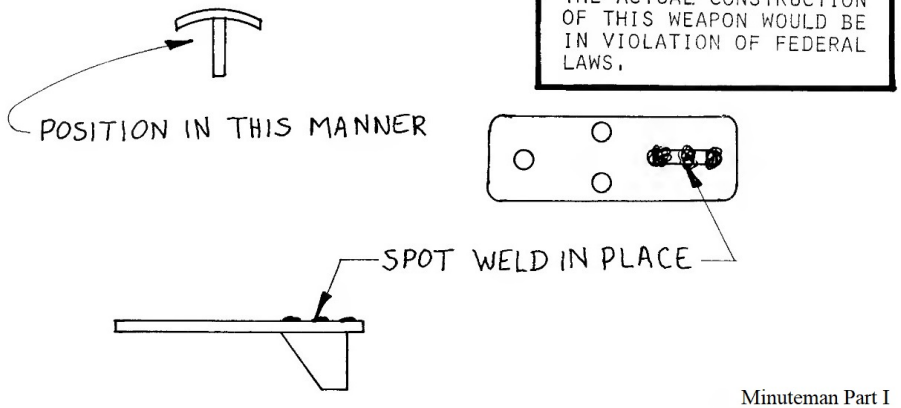
*NOTE: LOADING RAMP CUT USE 1/2" END MILL



THIS SERIES OF HOLES (4) LOCATED 90° APART - THE ONE LOCATED 180° FROM THE 30° CUT, IS THE BARREL LOCK SCREW AND HAS TO BREAK THRU. (4) D&T #10-32

NOTE: DRILL THRU WITH 23/32" THREADED SECTION WILL NOT HAVE FULL DEPTH OF THREAD - BUT SUFFICIENT

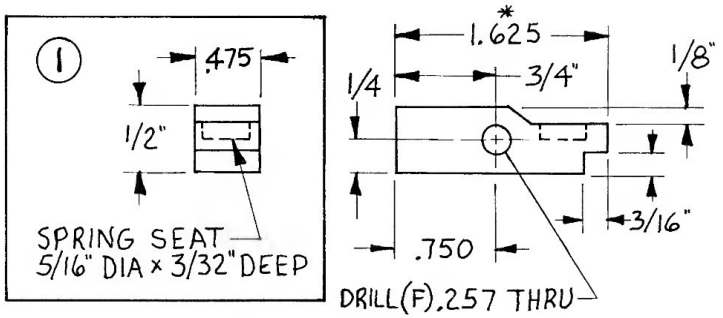
LOADING RAMP & BARREL ALIGNMENT PLUG - MTL 6061-T6 ALUM

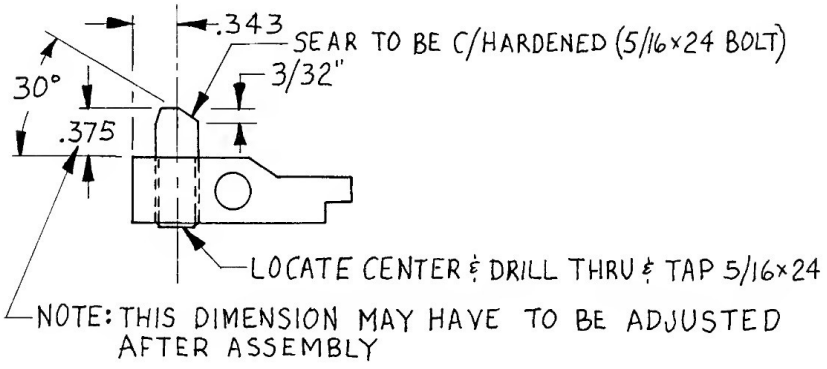


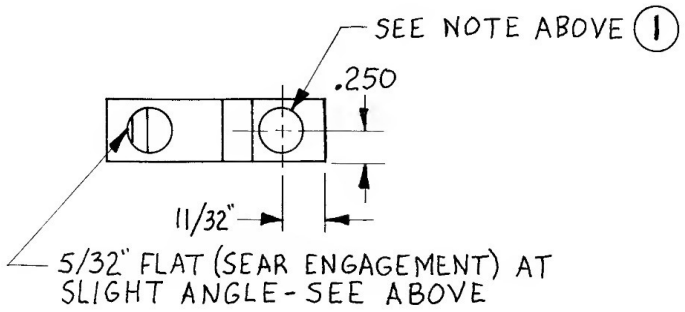
- WARNING -

THE ACTUAL CONSTRUCTION OF THIS WEAPON WOULD BE IN VIOLATION OF FEDERAL LAWS.

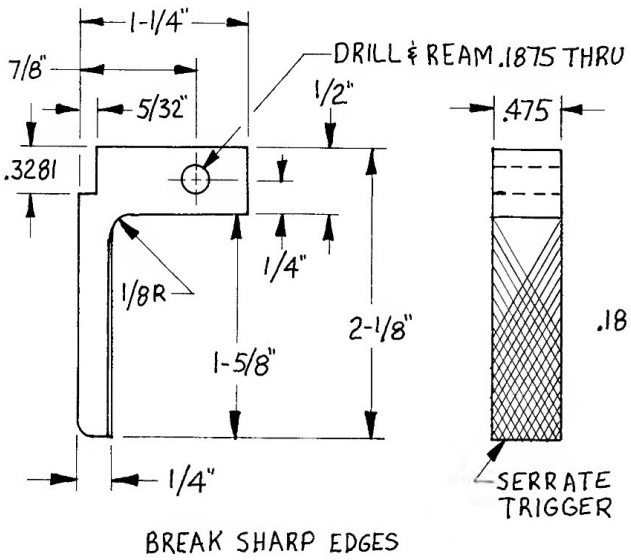
SEAR, SEAR PIVOT PINS & SPRING
STL MILD 1/2" × 1/2"

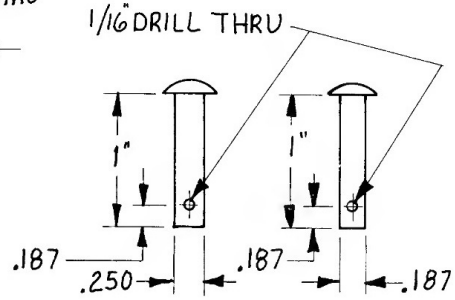



.343
SEAR TO BE C/HARDENED (5/16×24 BOLT)
30°
3/32"
.375
LOCATE CENTER & DRILL THRU & TAP 5/16×24
NOTE: THIS DIMENSION MAY HAVE TO BE ADJUSTED AFTER ASSEMBLY



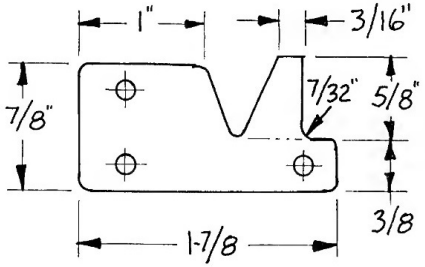
TRIGGER-MTL-ALUM 6061 FLAT SLK





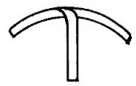
(2) COTTER PINS 1/2" × 1/16" DIA.
(1) SPRING PURCHASED
15/64" DIA × 5/8" LONG

EJECTOR - 1/16" THICK SHEET METAL. CAN BE CUT FROM SAME MATERIAL AS HOUSING, AS RADIUS MATCHES



- WARNING -

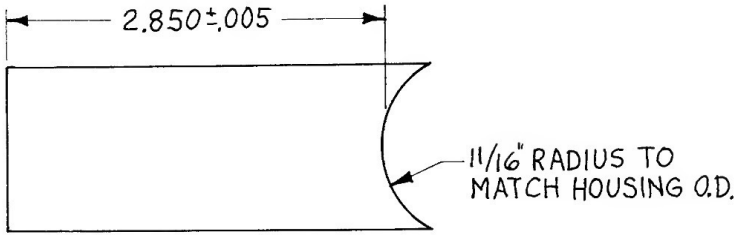
THE ACTUAL CONSTRUCTION OF THIS WEAPON WOULD BE IN VIOLATION OF FEDERAL LAWS.

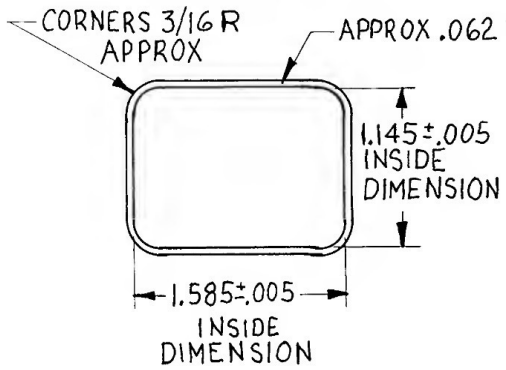


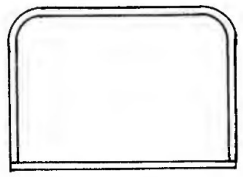
BEND DOWN ALONG DOTTED LINE 90°

(3) CLEARANCE HOLES FOR 6-32 SCREWS, APPROX IN THE ABOVE LOCATIONS. SCREW LENGTH FROM HEAD 1/8" LONG.

MAGAZINE HOUSING, MTL. .062 SHEET METAL

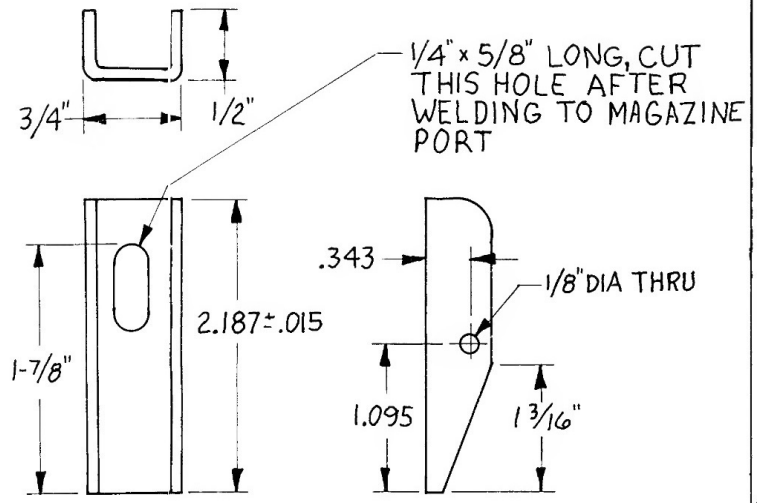






WILL WORK VERY WELL CONSTRUCTED IN THIS THIS MANNER, BY SPOT WELDING PLATE ALONG SIDES (FULL LENGTH)

MAGAZINE RELEASE, STL.



NOTE: CAN BE MADE FROM 3/4 x 3/4 SQ. TUBING

- WARNING -

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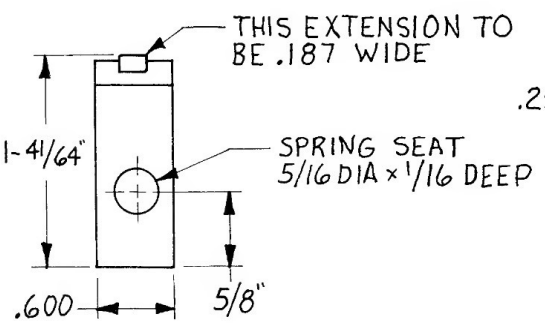
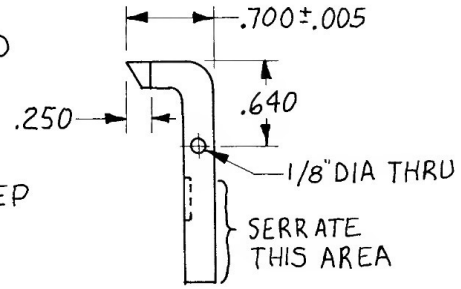
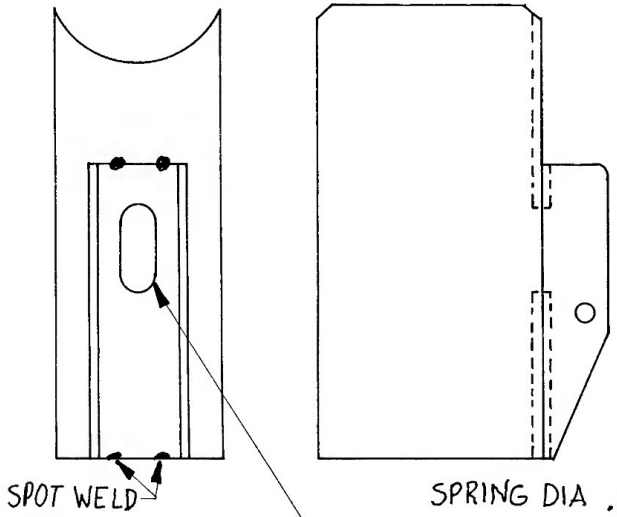
ASSEMBLY OF MAGAZINE HOUSING & MAGAZINE RELEASE

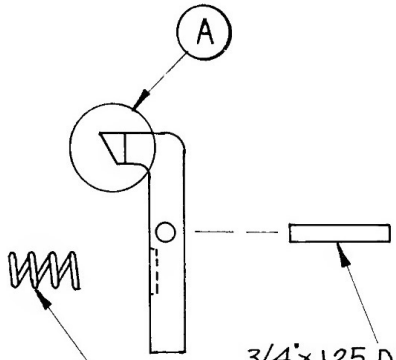
(A) IT PROBABLY WILL BE NECESSARY TO DO SOME ADJUSTING OR HANDFITTING HERE TO GET THE PROPER FIT, AND AMOUNT OF ENGAGEMENT — BUT ONLY AFTER MAGAZINE HOUSING HAS BEEN WELDED TO HOUSING.

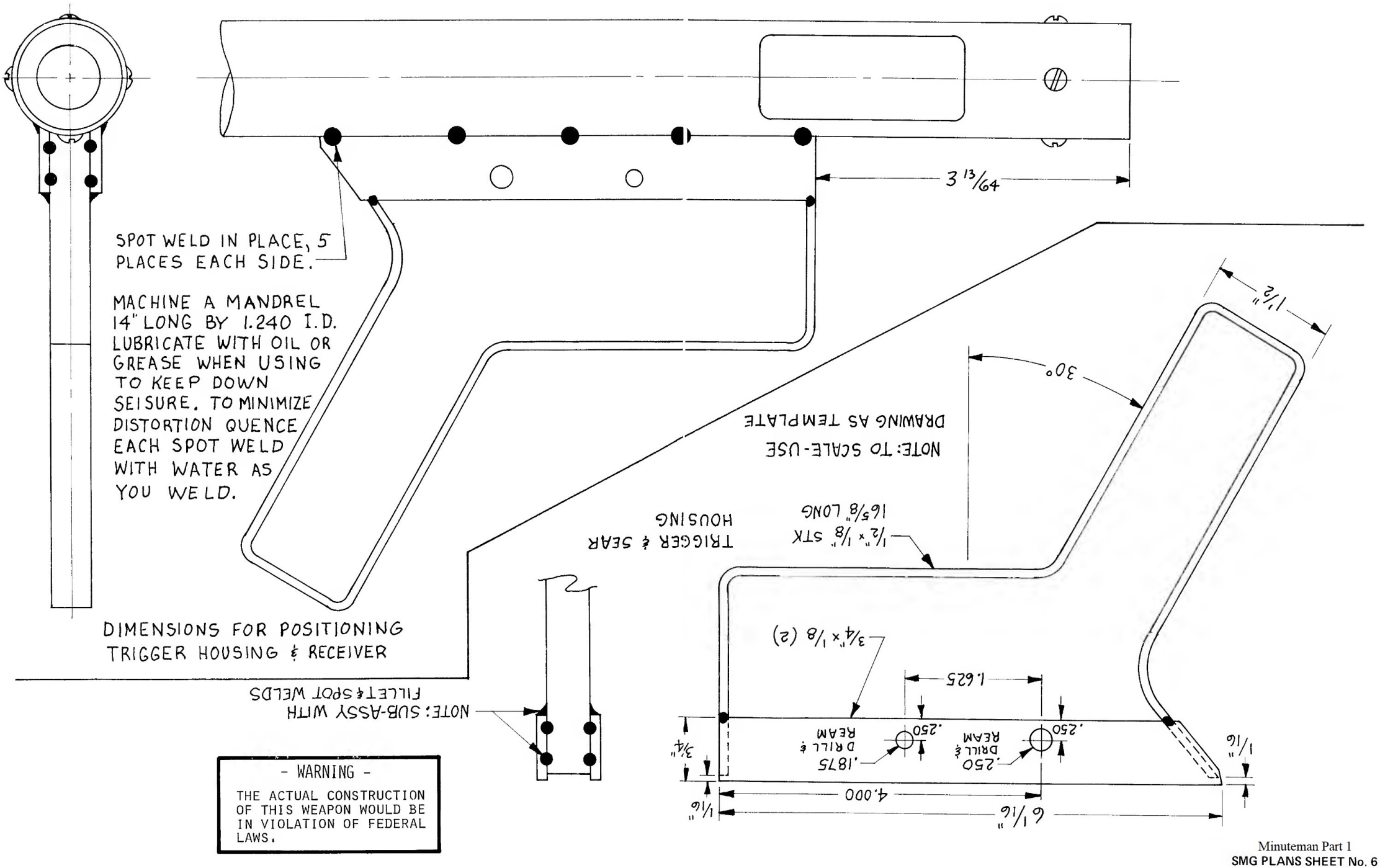






AFTER SPOT WELDING THESE (2) PARTS TOGETHER, BREAK THRU BOTH PARTS.

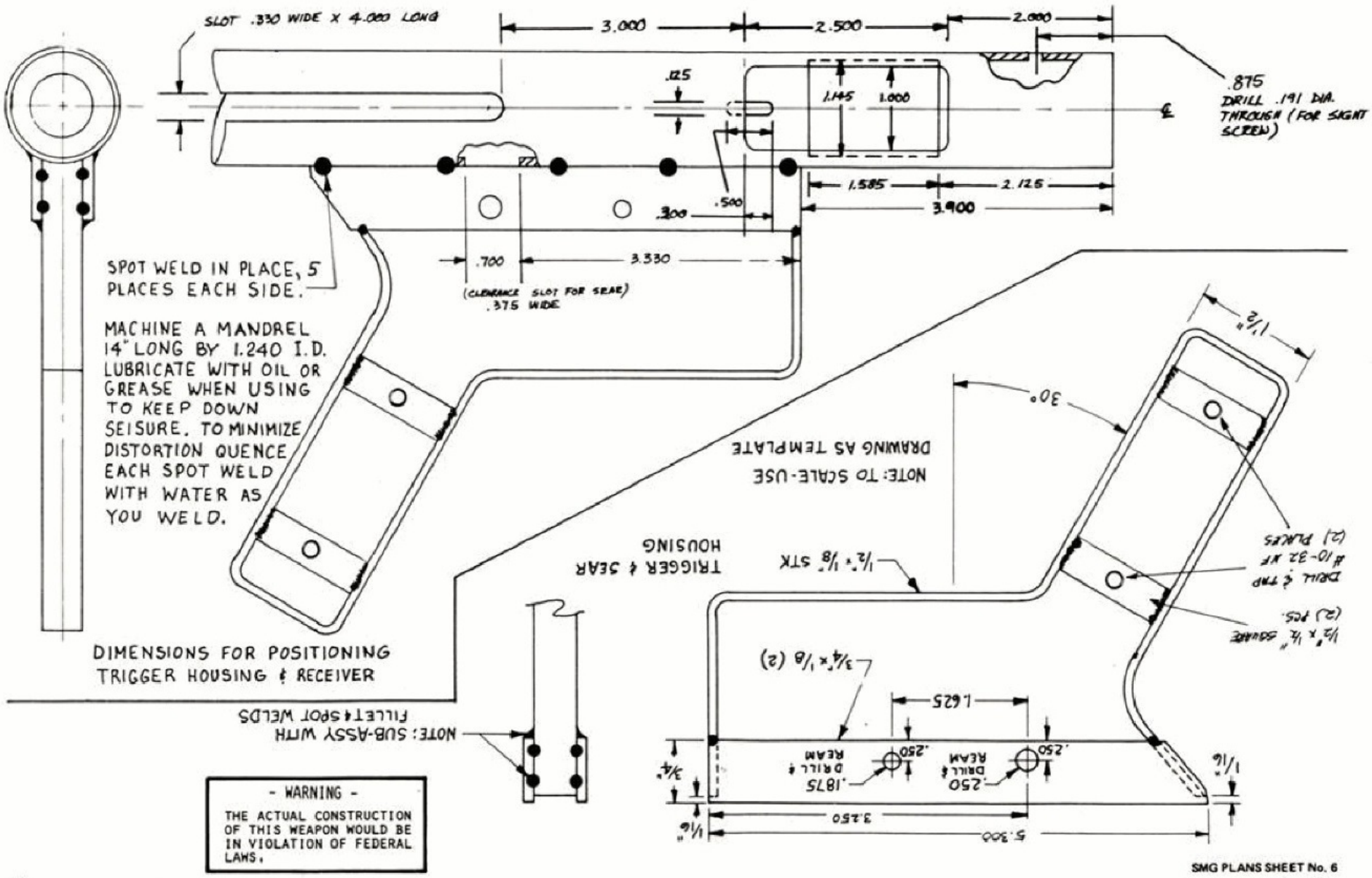



SPOT WELD IN PLACE, 5 PLACES EACH SIDE.
MACHINE A MANDREL 14" LONG BY 1.240 I.D. LUBRICATE WITH OIL OR GREASE WHEN USING TO KEEP DOWN SEISURE. TO MINIMIZE DISTORTION QUENCE EACH SPOT WELD WITH WATER AS YOU WELD.
3 13/64
DIMENSIONS FOR POSITIONING TRIGGER HOUSING & RECEIVER
NOTE: SUB-ASSY WITH FILLET & SPOT WELDS
NOTE: TO SCALE-USE DRAWING AS TEMPLATE
30°
1 1/2"
1/2" x 1/8" STK 16 5/8" LONG
TRIGGER & SEAR HOUSING
3/4" x 1/8" (2)
1.625
.250 DRILL & REAM
.1875 DRILL & REAM
.250
3/4"
1/16"
4.000
6 1/16"
1/16"

- WARNING -

THE ACTUAL CONSTRUCTION OF THIS WEAPON WOULD BE IN VIOLATION OF FEDERAL LAWS.

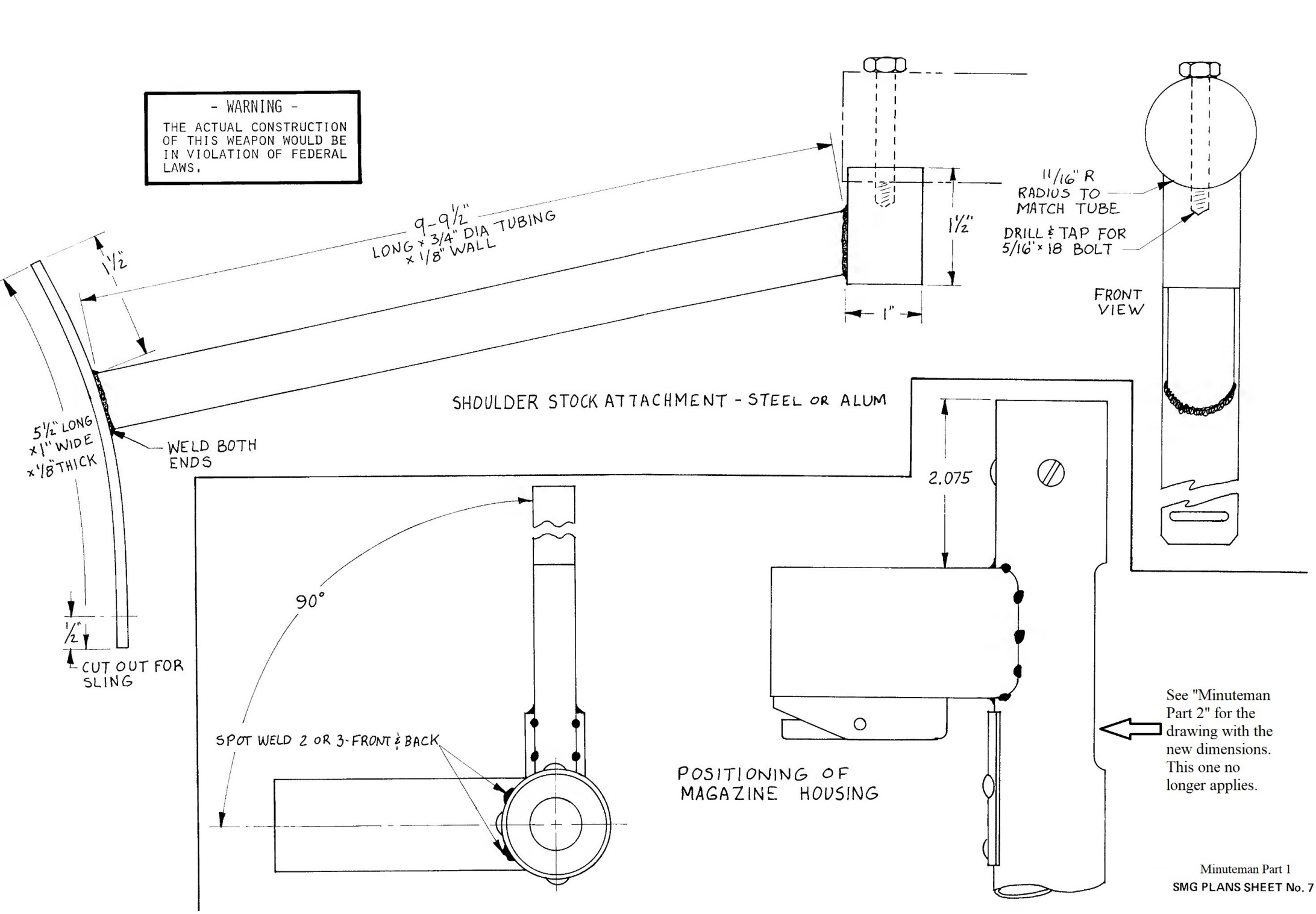
Additional page with changes made by Gary Hill

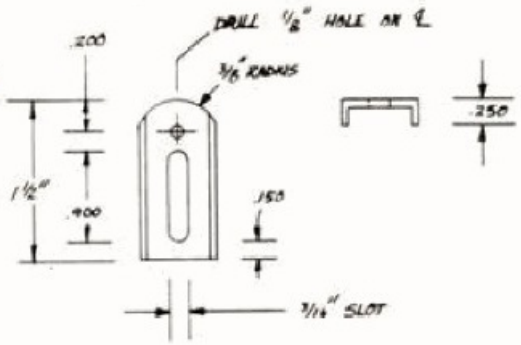


Updated dimensions for locating receiver and trigger housing.

Minuteman Part 1

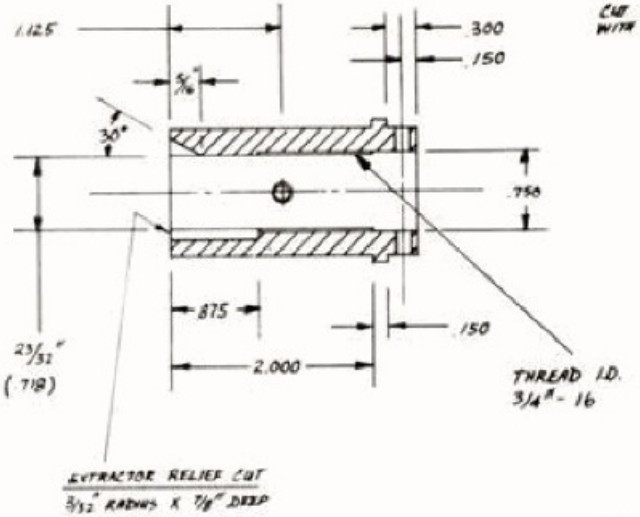
SMG PLANS SHEET No. 6 bis

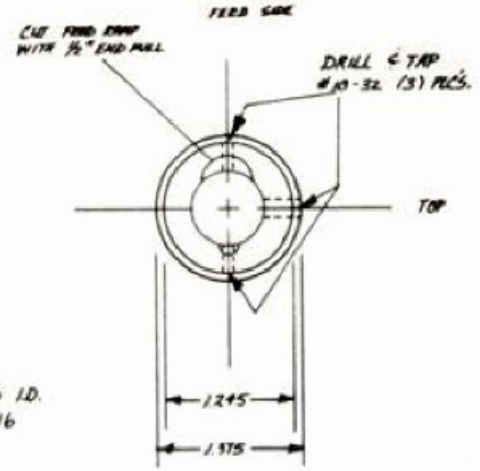

- WARNING -
THE ACTUAL CONSTRUCTION OF THIS WEAPON WOULD BE IN VIOLATION OF FEDERAL LAWS.
9-9½" LONG x 3/4" DIA TUBING x 1/8" WALL
1½"
1½"
1"
11/16" R RADIUS TO MATCH TUBE
DRILL & TAP FOR 5/16" x 18 BOLT
FRONT VIEW
5½" LONG x 1" WIDE x 1/8" THICK
WELD BOTH ENDS
SHOULDER STOCK ATTACHMENT - STEEL OR ALUM
2.075
90°
½"
CUT OUT FOR SLING
SPOT WELD 2 OR 3-FRONT & BACK
POSITIONING OF MAGAZINE HOUSING
See "Minuteman Part 2" for the drawing with the new dimensions. This one no longer applies.



REAR SIGHT

MAKE FROM 3/4" X 3/4" SQUARE TUBING .049 WALL.

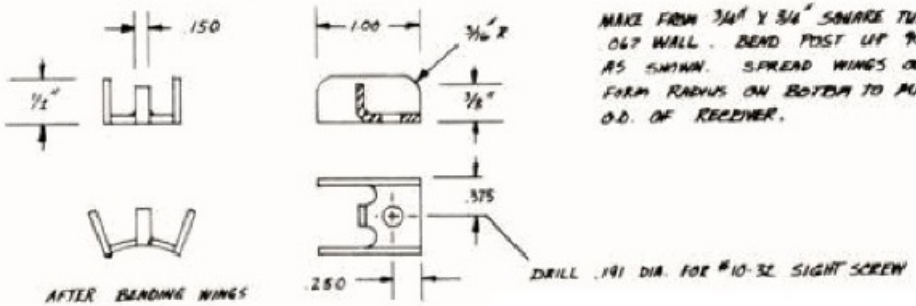


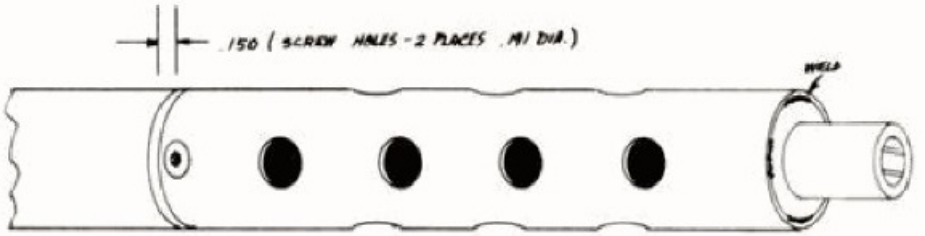


BARREL BUSHING - 4130 STEEL

FRONT SIGHT

MAKE FROM 3/4" X 3/4" SQUARE TUBING, .049 WALL. BEND POST UP 90° AS SHOWN. SPREAD WINGS OUT & FORM RADIUS ON BOTTOM TO MATCH O.D. OF RECEIVER.

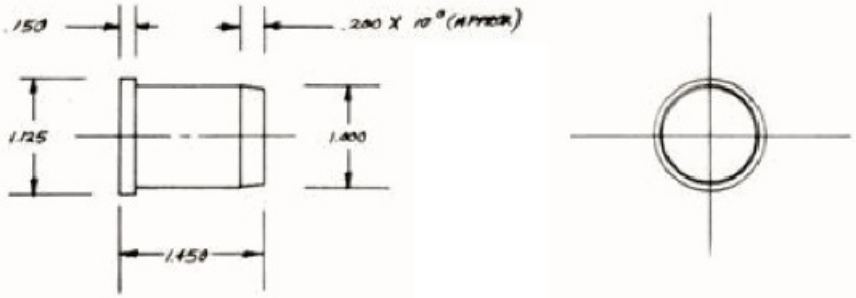




VENTILATED HANDGUARD

MADE FROM SAME M'TL AS RECEIVER

MAKE STEEL BUSHING 1.245 OD X .760 ID 1/4" LONG - PRESS INTO HANDGUARD & WELD



RECOIL BUFFER

Additional page with changes made by Gary Hill

Minuteman Part 1

SMG PLANS SHEET No. 8